

Date: Monday, 1/7/2008 3:38:46 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001	Dart Helicopters Services	Drawing Name	BEARING ASSEMBLY
Job Number	36638			
Estimate Number	11136			
P.O. Number	N/A	S.O. No.	N/A	
This Issue	1/7/2008			
Prsht Rev.	NC			
First Issue	N/A	Type	MACHINED PARTS	
Previous Run	36369			
Written By				
Checked & Approved By				
Comment	Est	A	04.02.18	New issue KJ/DS

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	MDELRINR1000	Delrin Round Bar 1" Comment: Qty.: 0.0350 f(s)/Unit Total : 1.3986 f(s) Delrin Round Bar 1" 4.0000 Material: Ø1.00 Delrin Rod (M-DELRIN-R1.000) Identify as D3183-9 Batch: M103164 J.F.
2.0	HARDINGE	HARDINGE CNC LATHE SMALL Comment: HARDINGE CNC LATHE SMALL Turn D3183-9 Cap as per Folio FA388 Deburr J.F. 08/01/14
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE Comment: INSPECT PARTS AS THEY COME OFF MACHINE J.F. 08/01/14
4.0	QC8	SECOND CHECK Comment: SECOND CHECK J.F. 08/01/15 100
5.0	D31835	Bearing Comment: Qty.: 1.0000 Each(s)/Unit Total : 40.0000 Each(s) Pick: B36648 X50 Qty Part Number Description Batch 1 D3183-5 Bearing B36387 X8 J.F. 08/01/15 58

W/I/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08/01/15	8	42- D3183-9 5th alone w/o 36638			u	08-01-15	42	u	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: LD Date: 08/01/15
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Monday, 1/7/2008 3:38:46 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARING ASSEMBLY

Job Number: 36638

Part Number: D3183045

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Press D3183-5 Bearing into D3183-9 Cap as per Dwg D3183.

Onk 08/01/15

(58)

7.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

BB 08-01-15

(58)

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST75*

BB 08/01/15

(58)

9.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

BB 08/01/16

(58)

Job Completion



BB 08/01/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	36638
Description: Cap	Part Number:	D3183-9
Inspection Dwg: D3183	Rev: C1	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	J-F.	Audited by:	S.F	Prototype Approval:	N/A
Date:	08/01/14	Date:	08/01/14	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.20	New Issue (P/O D3183-045)	KJ/RF	
B	06.03.09	Dimension Ø0.830 was Ø0.850	KJ/JLM	

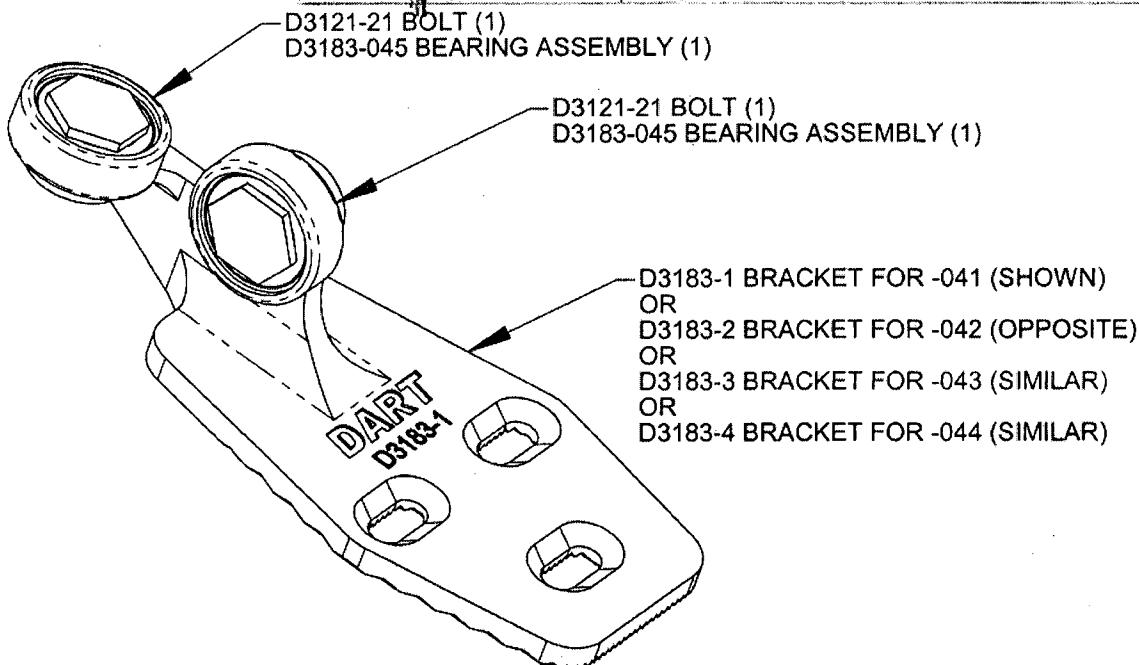


1 COPY ISSUED

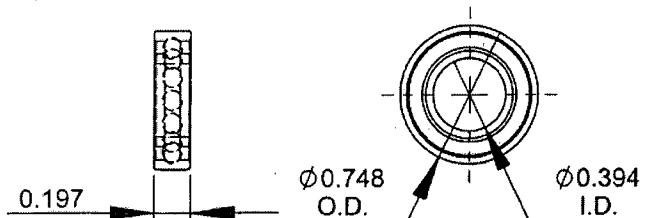
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. C
		D3183	SHEET 1 OF 4

DATE 04.02.17 TITLE SCALE 1:1

DESEALED
04.03.01



D3183-041 BRACKET ASSEMBLY (SHOWN)
D3183-042 BRACKET ASSEMBLY (OPPOSITE)
D3183-043 BRACKET ASSEMBLY (SIMILAR)
D3183-044 BRACKET ASSEMBLY (SIMILAR)

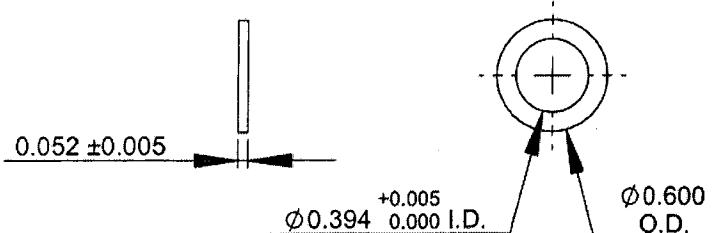


D3183-5 BEARING: SPECIFICATION CONTROL DRAWING

1) SINGLE ROW, DEEP GROOVE, CONRAD TYPE, SHIELDED SHOP COPY
 2) POSSIBLE SUPPLIER: NSK P/N 6800ZZ REVISION ZZ TO
 3) ALL DIMENSIONS ARE IN INCHES ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 36638

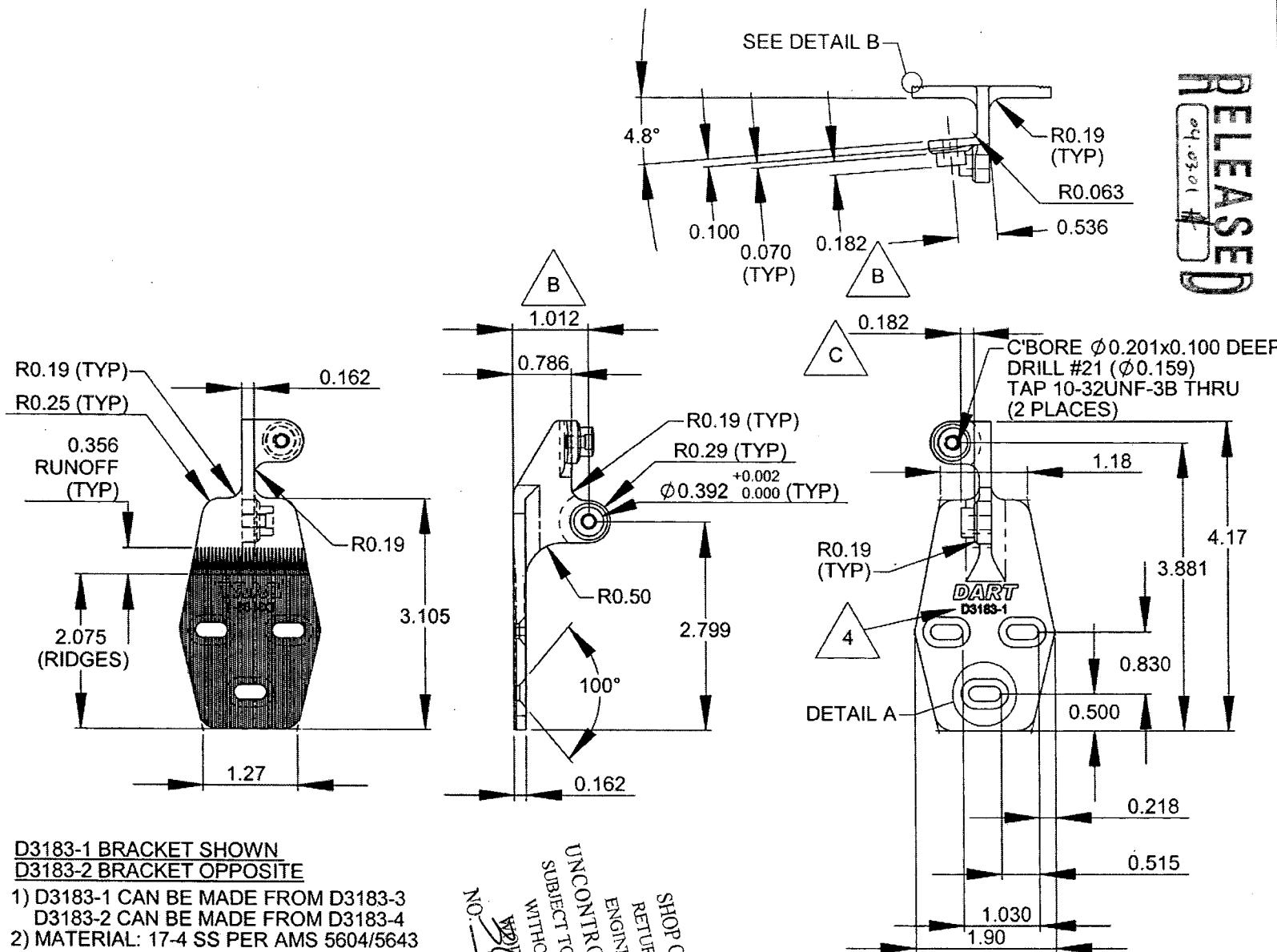


D3183-7 WASHER

1) MATERIAL: AISI 303 ROUND BAR (M303R)
 ANNEALED
 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
 3) TOLERANCES ARE PER DART QSI 018
 UNLESS OTHERWISE NOTED
 4) ALL DIMENSIONS ARE IN INCHES

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		HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	REV. C	
		DRAWING NO.	D3183
DATE	04.02.17	TITLE	BRACKET ASSEMBLY
		SHEET 2 OF 4	
		SCALE	1:2

D3183-1 BRACKET SHOWN
D3183-2 BRACKET OPPOSITE

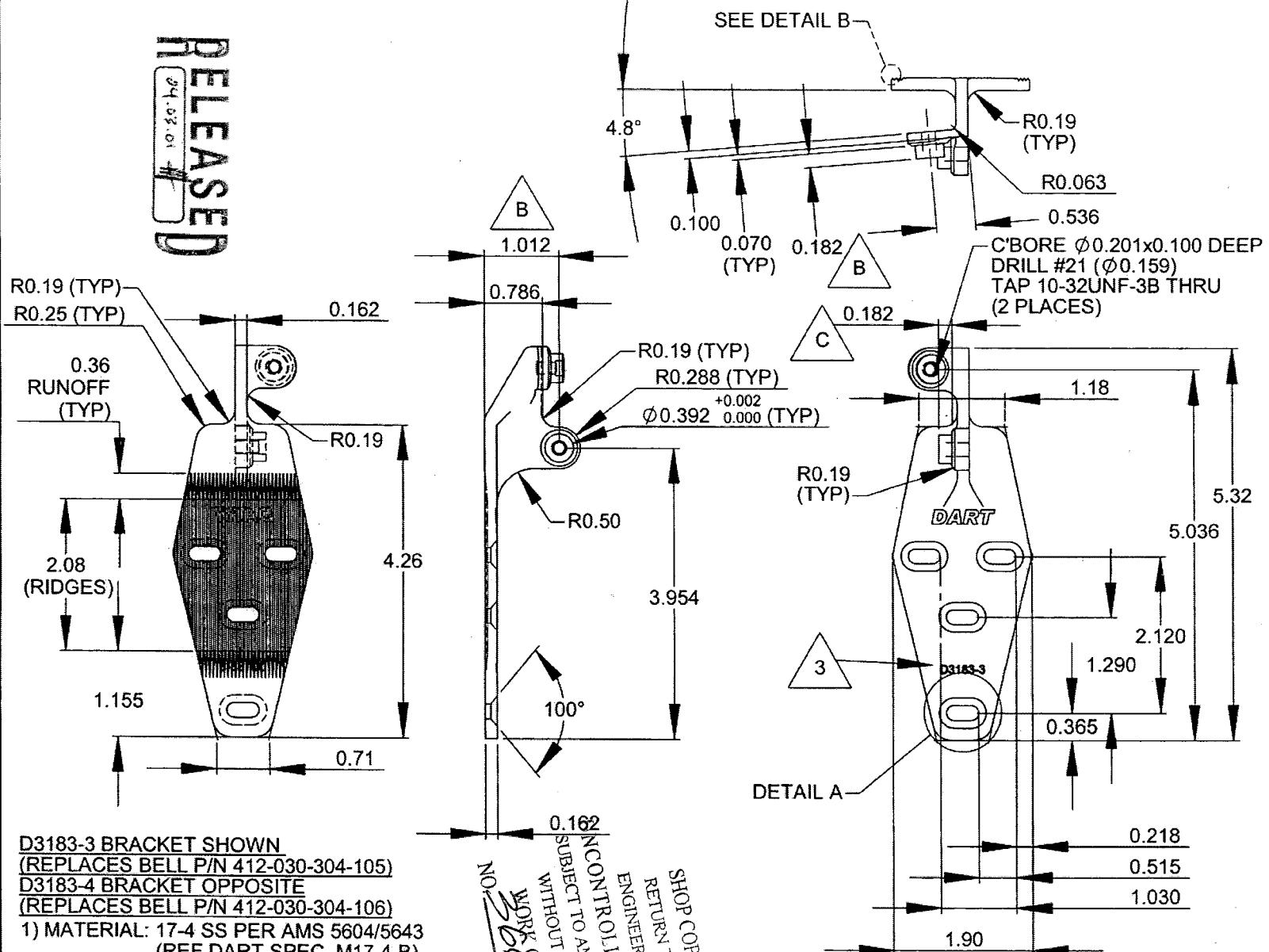
- 1) D3183-1 CAN BE MADE FROM D3183-3
D3183-2 CAN BE MADE FROM D3183-4
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE STRENGTH = 150 ksi
MIN YIELD STRENGTH = 100 ksi
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ENGRAVE DART P/N & LOGO AS SHOWN
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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D3183-1

DART

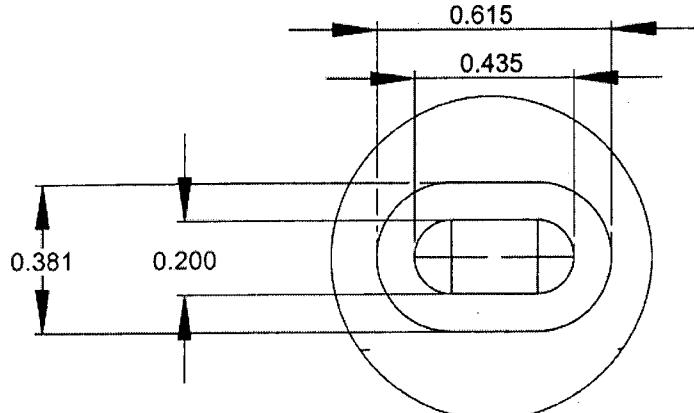
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DATE	DRAWING NO.	D3183
04.02.17	SHEET 3 OF 4	REV. C
TITLE	SCALE	1:2



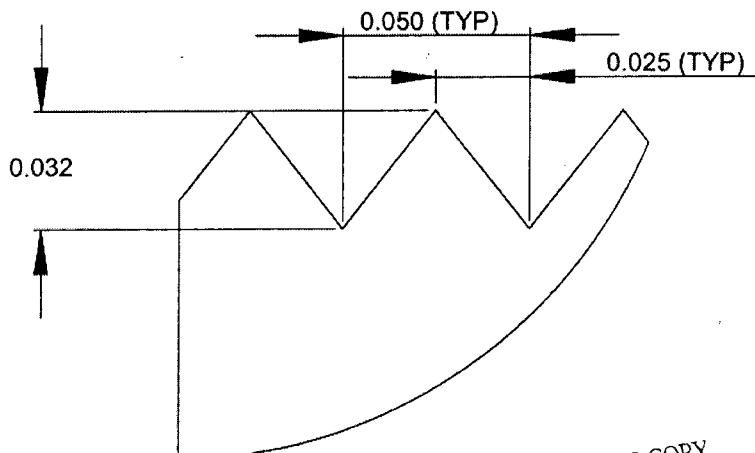


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DATE	04.02.17	DRAWING NO.	REV. C
		D3183	SHEET 4 OF 4
		TITLE	SCALE
		BRACKET ASSEMBLY	1:1

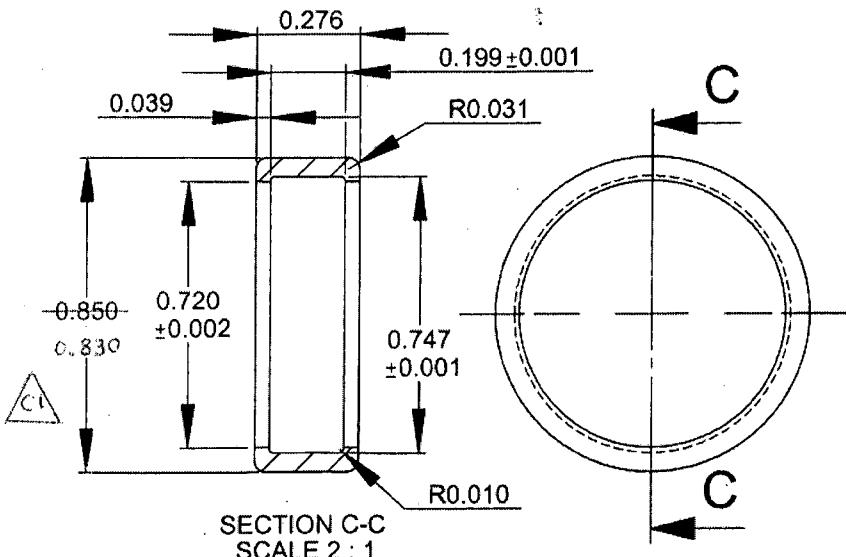


DETAIL A (2 : 1)

RELEASED
04.03.01



DETAIL B (20 : 1)



SECTION C-C
SCALE 2 : 1

D3183-9 CAP

1) MATERIAL: DELRIN ROD, Ø1.00
(REF DART SPEC. M-DELRIN-R1.00)
2) TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES

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NO. 36638

D3183-045 BEARING ASSEMBLY

1) ASSEMBLE D3183-5 BEARING AND
D3183-9 CAP

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